

Work Order ID 74210

Tuesday, September 27, 2011 10:45:16 AM

Page 1

Item ID: D206-642-151

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 10/3/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-09-27 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

} SAD 11-10-13

> BE 11/10/14

} SAD 11-10-17

> 11-10-17

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

QC6- Inspect dimensions to drawing 0.00

Memo

0.00

S. 10/1/18

120



QC

Quality Control

11-10-17

11/10/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DC
4/10/18

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DS

11-10-18

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

> DS 11-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/10/10

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

BE 11/10/10

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 11-10-18 Time: 5:00pm

Finish Date: _____ Time: _____

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ M118393

Sikaflex expire date: 12-5-5

SAD 11-10-18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Replacement Skidtube

Stop



Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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Item ID: D206-642-151 Accept  Setup Start 
Revision ID: Stop 
Item Name: Replacement Skidtube
Start Date: 10/3/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 11/4/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200  Skidtubes	Skidtubes	0.00							
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Skidtubes

Memo 0.00

1-remove alodine from around hole and prepare for welding *BE 11/10/19*

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ Aluminum Rod ☒ *M117884* *BE 11/10/19*

3-Grind welds flush as per Dwg D3804. *BE 11/10/19*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/R ☐ SS Rod ☒ *NONE* *BE 11/10/19*

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr *DD* *11-10-19*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 8

Accept

Setup Start

Stop

Abstract

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

**Insp.
Stamp**

0,00

[illegible]

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

0.00

[illegible]

QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

Quality Control

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

QC10- Inspect visual per QSI004- ground welds

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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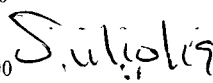

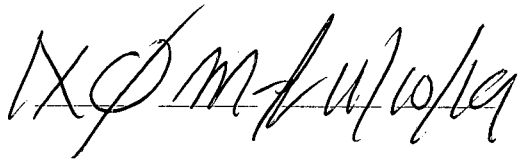

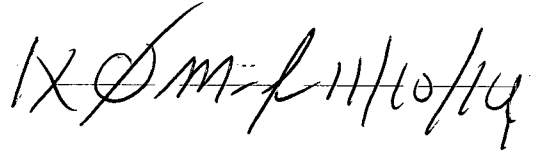
Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
240  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							
250  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00							

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320 OF
4:00

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 74210

Tuesday, September 27, 2011 10:45:16 AM

RH



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Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
270	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

1 RH, 0, 0, 10/20

1 RH, 0, 0, 10/20

W/O:		WORK ORDER CHANGES						
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<p>Memo</p> <p>1- Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 1119393 Sikaflex expire date: <input type="checkbox"/> 12/0</p> <p>2- Install wearplate as per dwg</p> <p>2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: 111988</p>	0.00							11 Wt / 8/10/20
290	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							8/10/20

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: _____

PPP Rev: _____

PPP74404

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/20 ①

11/10/20 ②

MF
11-10-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, September 27, 2011 10:45:12 AM

Page 1

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620

Manufactured

No

110

Each

23.0000

1

1



Skidtube, 206 Skidtube



SAD

11-10-13

Location

Loc Qty

Loc Code

LG

23

85

71616

5

71617

6

73781

5

73786

3

73787

4

D2647

Manufactured

No

110

Each

36.0000

1

1



Cap



Location

Loc Qty

Loc Code

LG002

36

55352

8

71171

28

CR3212-4-04

Purchased

No

180

Each

10,997.00

52

52



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

997

116471

78

117816

179

118686

1

118840

739

ST516

10000

119017

10000

52

BE 11/10/14
B73826 v1

BE 11/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1

Manufactured

No

180

Each

12.0000

1

1



Web



SAD 11-10-18

Location

Loc Qty

Loc Code

LG

12

73789

10

73790

2

B73794

①

D3286-1

Manufactured

No

180

Each

80.0000

2

2



Doubler



B74

Location

Loc Qty

Loc Code

LG002

80

64563

6

74111

74

②

①

11-10-17

D2649

Manufactured

No

200

Each

2,007.000

19

19



Cross Bolt Spacer



BE 11/10/19

Location

Loc Qty

Loc Code

LG

736

68224

2

71355

2

72704

2

72841

130

73855

600

2

LG001

1271

65317

1

68507

11

73390

59

73857

600

73860

600

17

Tuesday, September 27, 2011 10:45:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 74210

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3286-3 Manufactured No

200

Each

98.0000

2

2



Spacer

Location

Loc Qty

Loc Code

LG001

83

74117

83

LG002

15

64564

15

2

D2680-041 Manufactured No

210

Each

40.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

LG

40

73334

40

① DP 11-10-19

CR3212-4-03 Purchased No

210

Each

2,116.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1114

114859

1114

ST318

1000

119017

1000

② DP 11-10-19

AN960JD416 NAS1149D0463J Purchased No

210

Each

0.0000

1

1



Washer

AN11838J



(x1) 11/10/20

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:45:13 AM

Page 4

Work Order ID: 74210

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

210

Each

1,401.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

399

117086

21

117849

378

ST317

1000

119017

1000

② 11-10-19

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw



11-10-120

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

119124

x1

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug



11-10-120

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

1373827

x6

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Page 4

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 5

Work Order ID: 74210



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3

Manufactured No

270

Each

1,799.000

6

6



O-Ring



u 11/10/20

Location

Loc Qty

Loc Code

FP-A

1799

61962

12

66956

282

73489

505

73828

1000

X6

D3873-1

Manufactured No

280

Each

599.0000

14

14



Bushing



u 11/10/20

Location

Loc Qty

Loc Code

ST084

4

68247

4

ST088

595

64760

1

70690

47

71837

87

73399

60

73829

400

B73831

X14

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Page 5

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 6

Work Order ID: 74210

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

87.0000

1

1



Aft Cap



xl 11/10/20

Location

Loc Qty

Loc Code

FP004

43

68280

43

xl

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear

1374940



(x1) xl 11/10/20

MS27039-1-08

Purchased No

280

Each

1,216.000

2

2



xl 11/10/20

Screw

Location

Loc Qty

Loc Code

ST291

1216

115108

16

117423

300

118378

400

118910

500

x2

Tuesday, September 27, 2011 10:45:13 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 10:45:13 AM

Page 7

Work Order ID: 74210

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

280 Each

8,411.000

7

7



Nut



Handwritten: 4/10/20

Location

Loc Qty

Loc Code

ST300

2411

117441

16

117601

240

117885

155

118451

1000

118927

1000

Handwritten: x7

ST516

6000

119017

6000

D3805-045

Manufactured No

280 Each

6.0000

1

1



Wearplate Assembly Aft, Low Gear



Handwritten: (x1) 4/10/20

Handwritten: 1373 817

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased No

280 Each

0.0000

2

2



Washer

Handwritten: 117087



Handwritten: (x2) 4/10/20

AN3-37A

Purchased No

280 Each

261.0000

7

7



Bolt



Handwritten: 4/10/20

Location

Loc Qty

Loc Code

ST353

211

111668

111

118628

100

Handwritten: x7

ST354

50

117619

50

Tuesday, September 27, 2011 10:45:13 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, September 27, 2011 10:45:13 AM

Page 8

Work Order ID: 74210



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

4,404.000

7

7



Washer

M *u.110fz*

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

#74210

RELEASED
UP 09.03.03
per ECN 09-598

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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* 74210



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

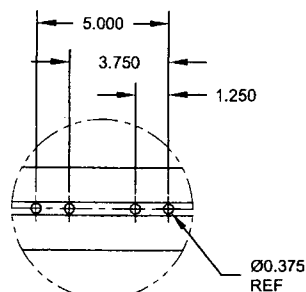
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

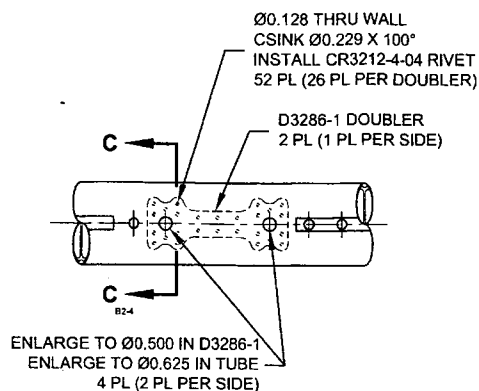
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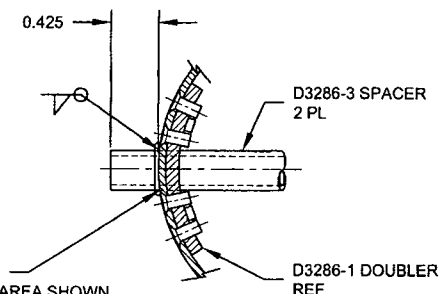
RELEASED
UP 09.03.07



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

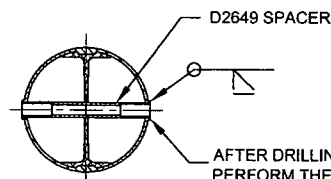


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH
- # 74210

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
DE APPR.	97	TITLE	SCALE
DATE	08.07.07	SKIDTUBE ASSEMBLY, 206A/B	NTS
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RELEASED
97 09.03.03

#74210

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G

SCALE NONE

A7-5

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

C7-5

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E

SCALE NONE

B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F

SCALE NONE

B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 272

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 73871
Part number: D 206-1042-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal Davis Date of Test Coupon 11-10-12

Welder Barclay Elliott Date of Test Coupon 11-10-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld